

Work Order ID 61057

Wednesday, August 04, 2010 1:32:42 PM



Page 1

Item ID: D3910-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Crosstube Lug

Start Date: 8/4/2010 Start Qty: 8.00



Cust Item ID:

Required Date: 8/11/2010 Req'd Qty: 8.00

Customer:

Reference:

Run Start



Approvals: Process Plan: ME

Date: 10-8-04

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D3910

B

100

0.00



Bandsaw

Jeaspa Bandsaw

Memo

Cut to 1.450" Long

0.00

LF 10/08/08

8

8

110

0.00



HAAS 1

HAAS CNC vertical machine #1

Memo

MACHINE AS PER FOLIO FA865 AND DWG

FOLIO REV: AA

DWG REV: B

DEBURR

0.00

LF 10/08/08

8

8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

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Run Start

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool # Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC2- Inspect parts off machine FAI/FAIB

0.00

QC

Memo

0.00

Quality Control

130

QC8- Inspect parts - second check

0.00

QC

Memo

0.00

Quality Control

140

Chemical Conversion Coat per QSI005 4.1

0.00

HandFinish

Memo

0.00

Hand Finishing

SP 10/08/08

10/10/08.09

8 0

8 7

m 10 08 09 8

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Approvals: Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

Powdercoat

Memo

0.00

Powder Coating

160

QC3- Inspect Part Finish

0.00

QC

Memo

0.00

Quality Control

170

Identify as per dwg & Stock Location: S07

0.00

Packaging

Memo

0.00

Packaging

W/O:		WORK ORDER CHANGES						
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Cust Item ID:

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

10/08/11 *[Signature]*
mf
10-8-11

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NOTE: Date & initial all entries

Picklist Print

Wednesday, August 04, 2010 1:32:41 PM

Page 1

Work Order ID: 61057



Parent Item: D3910-3



Parent Item Name: Crosstube Lug

Start Date: 8/4/2010

Required Date: 8/11/2010

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP REV:A NEW ISSUE 09-11-25 JLM VERIFIED BY:DD
REV:B AS PER REV B 10-03-23 JLM VERIFIED BY:DD IPP

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D2423		Manufactured	No			100	f	380.3221	0.13	1.094737			
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Lug Extrusion

Location

Loc Qty

Loc Code

MAT06

380.3220795

43722

180

45800

200.322079

1.0948 S.P 10/08/08

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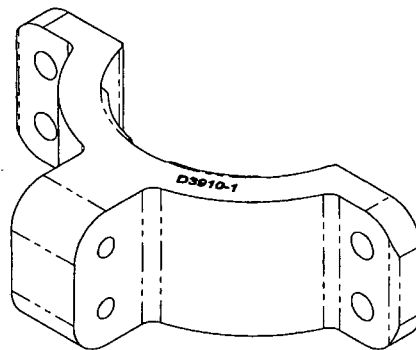
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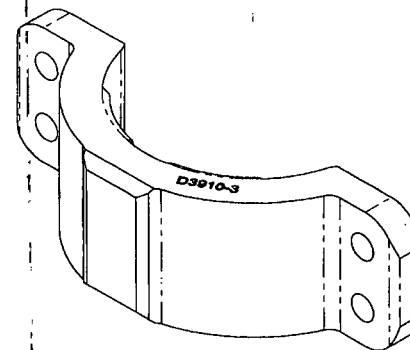
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D3910-1 X-TUBE LUG






D3910-3 X-TUBE LUG

#61057

NOTES:

- 1) MATERIAL: MAKE FROM D2423 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE PART NUMBER TO A DEPTH OF 0.010 \pm 0.005 IN THIS LOCATION WITH A TOOL TIP RADIUS OF 0.015 \pm 0.005
- 7) WEIGHT -1: 0.32 lbs
-3: 0.25 lbs

RELEASED
2010-03-22
MD

B	Ø0.257 HOLES: 4 PL WAS 2 PL (A3-2) & (A3-3); R0.34 FILLET WAS R0.50 (A3-2) & (A3-3). REASON: SEE TR-D390-007-2		JPH	10.03.16
A	NEW ISSUE		JPH	10.03.04
REV.	DESCRIPTION		BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	JPH			
CHECKED		DRAWING NO.	REV. B	
MFG. APPR.		D3910	SHEET 1 OF 3	
APPROVED		TITLE	SCALE	
DE APPR.		X-TUBE LUG (350)	NTS	
DATE	10.03.16	COPYRIGHT © 2010 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>		

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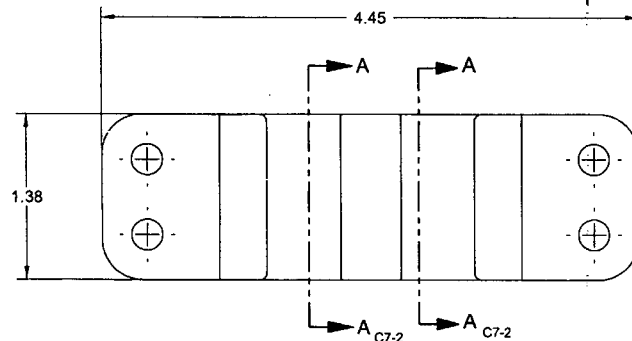
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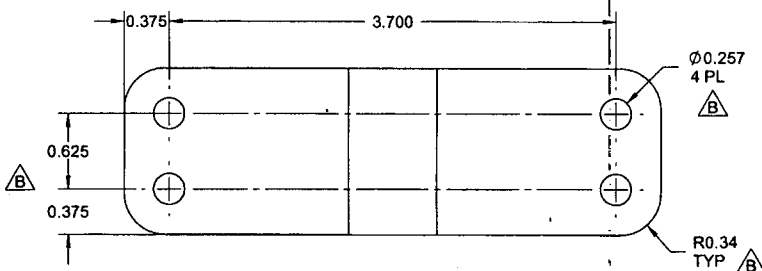
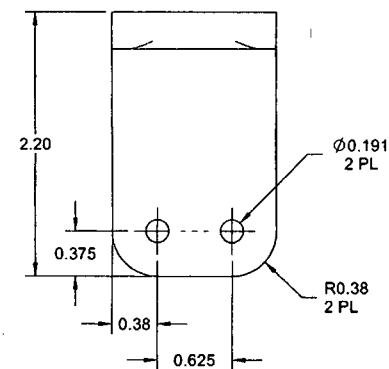
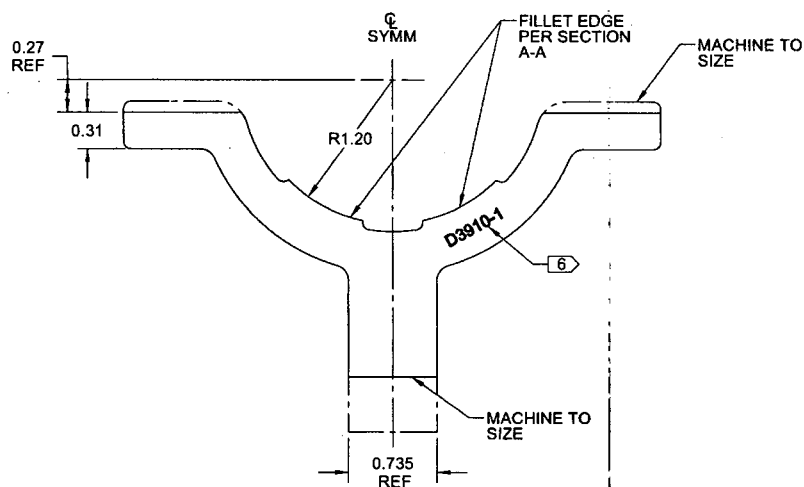


ROUND EDGE
R0.06 MIN - R0.10 MAX
2 PL

SECTION A-A
C4-2
C5-2



#61057



D3910-1 X-TUBE LUG

RELEASED
2010-03-22
W

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED	<i>[Signature]</i>	DRAWING NO. D3910	REV. B
MFG. APPR.	<i>[Signature]</i>	TITLE X-TUBE LUG (350)	SHEET 2 OF 3
APPROVED	<i>[Signature]</i>	SCALE	NTS
DE APPR.	<i>[Signature]</i>	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
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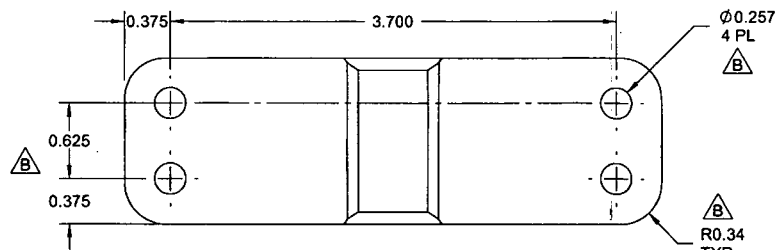
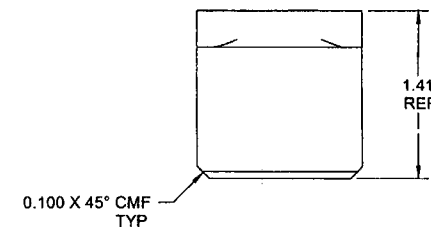
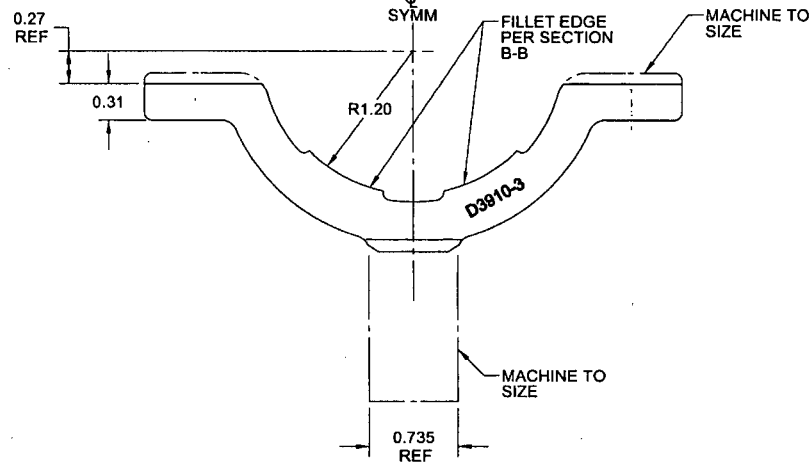
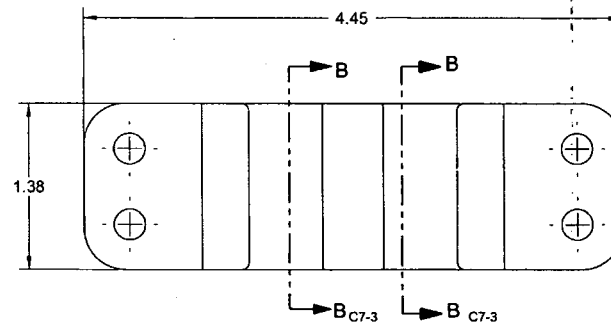
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

ROUND EDGE
R0.06 MIN - 0.10 MAX
2 PL

SECTION B-B
C4-3
C5-3



D3910-3 X-TUBE LUG

RELEASED
2010-03-22

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D3910	REV. B
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